

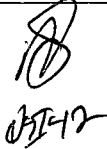


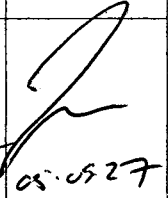
DART AEROSPACE LTD		Work Order:	24324
Description: Doubler		Part Number:	D3283-1
04.10.18 <i>AB</i> 04.10.18 <i>CP</i>			
Dwg: D3283 Rev. <i>AB</i> <i>05-09-22</i>		Qty:	10
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	<i>AB</i>	05.09.26	4
2	MV	Cut blanks: 15.550" x 2.000" 14.850" x 1.525" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3283-1 Batch: <i>M18556</i>	<i>J.L</i>	05.09.27	10
3	MV	Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-1	<i>J.L</i>	05.09.27	10
4	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	05.09.27	10
5	QC8	Second check	<i>RE</i>	05.09.27	10
6	MV	Deburr	<i>SAD</i>	05/10/01	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>SAD</i>	05/10/01	10
8	QC5	Inspect work to Step 7	<i>2</i>	05-10-03	10
9	ST	Identify and Stock	<i>DP</i>	05-10-13	10
10	AC	Cost / part <i>16.36</i>	<i>SUC</i>	05-10-18	10
11	DC	Close W/O <i>9.52</i> Inspect Level 21	<i>19</i>	05/10/17	10

Rev	Date	Change	Revised By	Approved
A	04.09.28	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 05.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-27	3	- 1 stack scraped - drilled hole manually at wrong place		- scrap + replace DESTROY	J.L 05-09-27	 05-10-17	 05-10-17	 05-09-27

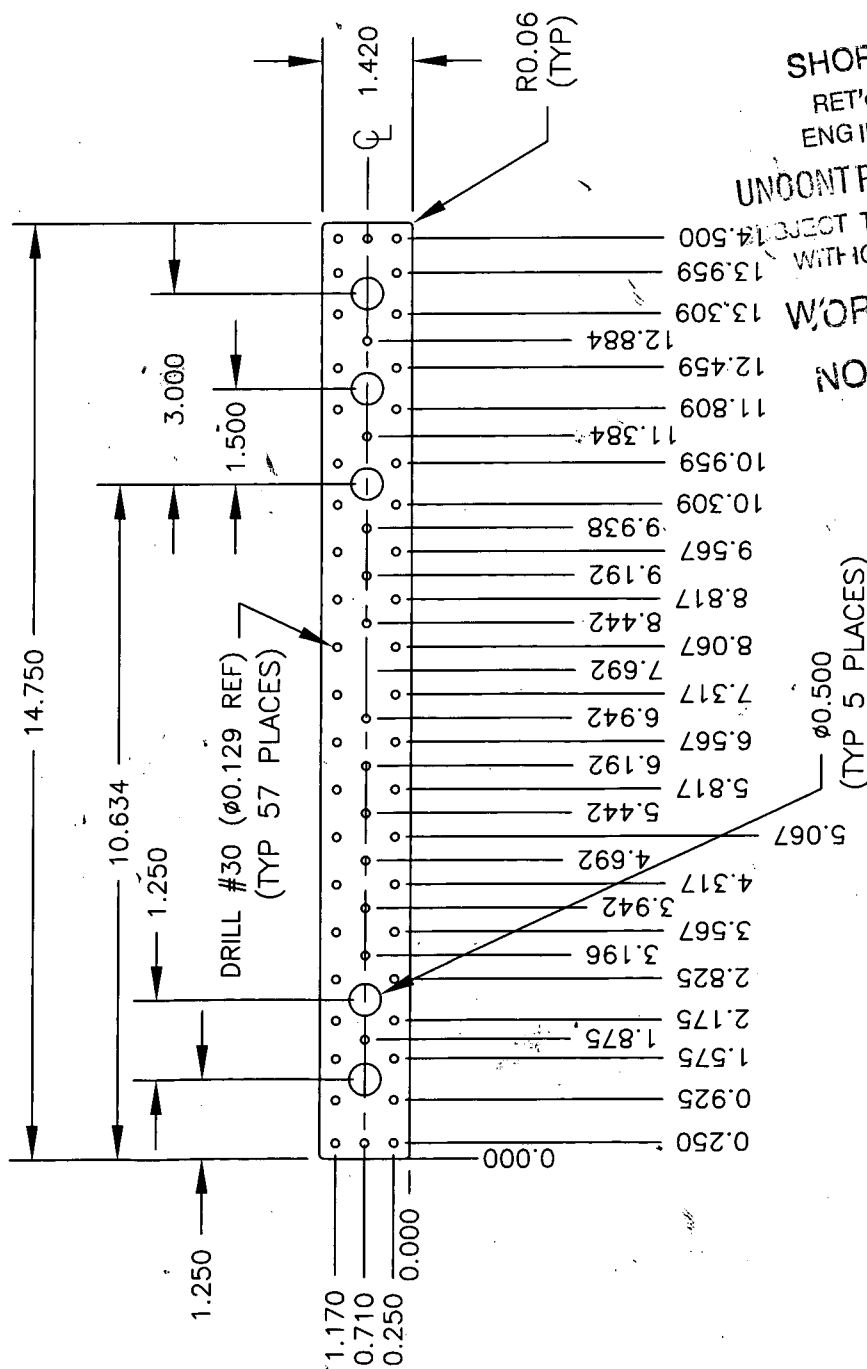
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE
0509.26

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3283	REV. D SHEET 1 OF 2
DATE 05.08.09	TITLE DOUBLER		SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024324
Project Name : D3283-1
Project For : WK541
Work Order Type : Main
Main WO Number :
House Part Number : D3283-1
Description : Doubler
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24324
Description: Doubler		Part Number: A3283-1
Inspection Dwg: A3283	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.750	+ .010	14.748	✓			
1.420	+ .010	1.421	✓			
1.170	+ .010	1.170	✓			
.710	+ .010	.710	✓			
.250	+ .010	.250	✓			
Ø.129	+ .005 - .001	.132	✓			
Ø.500	+ .004 - .001	.503	✓			
1.250	+ .010	1.250	✓			
10.634	+ .010	10.634	✓			
1.500	+ .010	1.500	✓			
3.000	+ .010	2.999	✓			
1.875	+ .010	1.875	✓			
.250	+ .010	.250	✓			
.925	+ .010	.925	✓			
1.575	+ .010	1.575	✓			
3.196	+ .010	3.195	✓			
4.692	+ .010	4.691	✓			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval:
Date: 05.09.27	Date: 05.10.27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	